

Date: Monday, 7/9/2007 2:29:14 PM
 User: Kim Johnston

Process Sheet

SF17

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: LUG EXTRUSION	
Job Number	33420	-2	Part Number	: D27317	
Estimate Number	10326		Drawing Number	: D2731 REV B	
P.O. Number	N/A		Project Number	: N/A	
This Issue	7/9/2007	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	NC		Material	: N/A	
First Issue	N/A	Type : MACHINED PARTS	Due Date	: 7/20/2007	
Previous Run	33136		Qty:	100	Um: Each
Written By					
Checked & Approved By		9/9-07.07.10			
Comment	Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC				

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion 
		Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: B23779.
2.0	BAND SAW	BAND SAW 
		Comment: BAND SAW Cut D2423 extrusion to .82" Batch_____
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling Machine per folio drawing D2731 Rev.B

4.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE Receive & Inspect for transit damage 
5.0	QC5 	SECOND CHECK 
		Comment: SECOND CHECK Inspect levels 5 Er 07/08/131 

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 33420

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR

07-08-31

(50)

7.0 POWDER COATING

POWDER COATING



M105068



(50)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BR

07-09-04

8.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



EP070910 60



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP070910 60



10.0 QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

EP070911

Job Completion



W 07-09-11

DART AEROSPACE LTD	Work Order:	33420
Description: Lug	Part Number:	D2731-7
Inspection Dwg: D2731	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

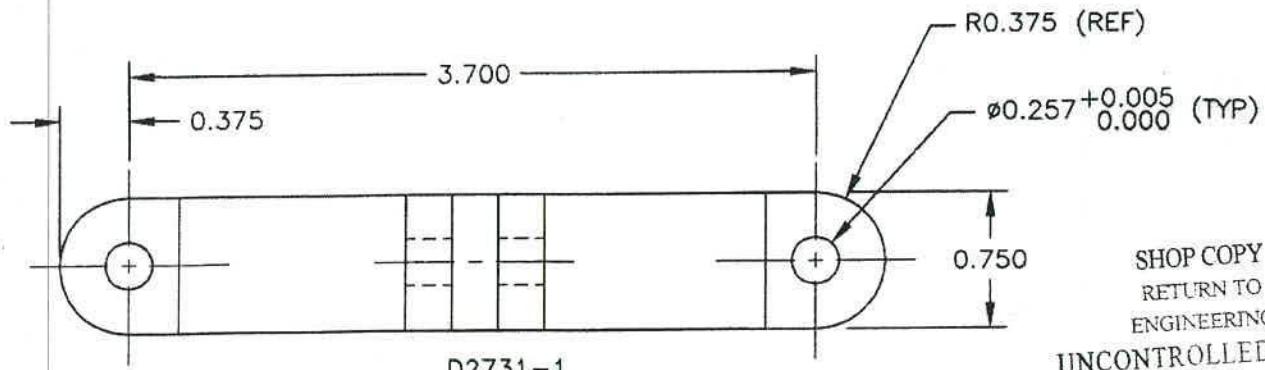
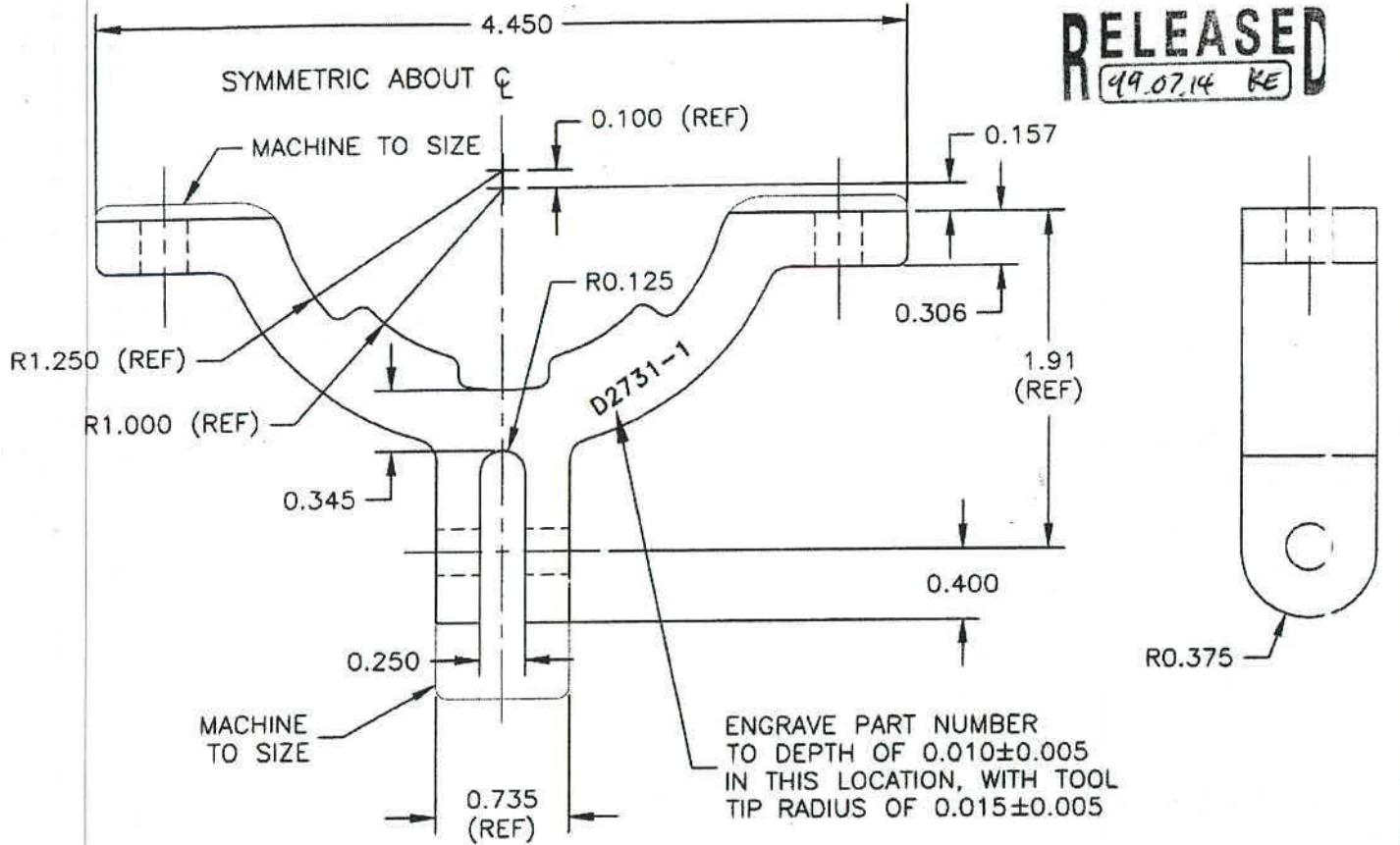
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	
B	04.05.06	Dimension change	KJ/RF	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO. D2731
KE	JK	REV. B SHEET 1 OF 4
DATE		SCALE 1:1
99.07.06		
A	98.05.13	NEW ISSUE
B	99.07.06	REVISED DIMENSIONS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

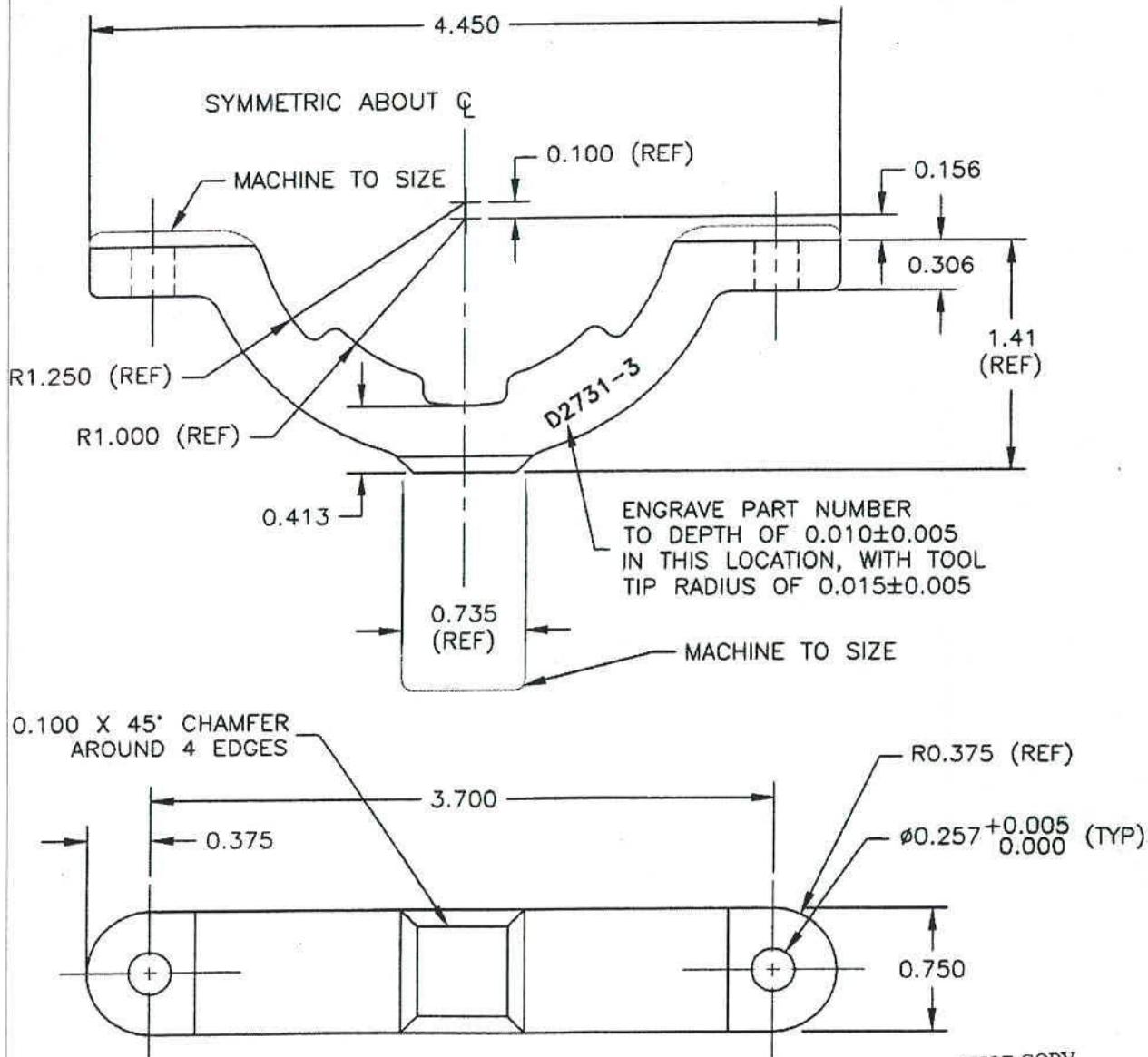
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

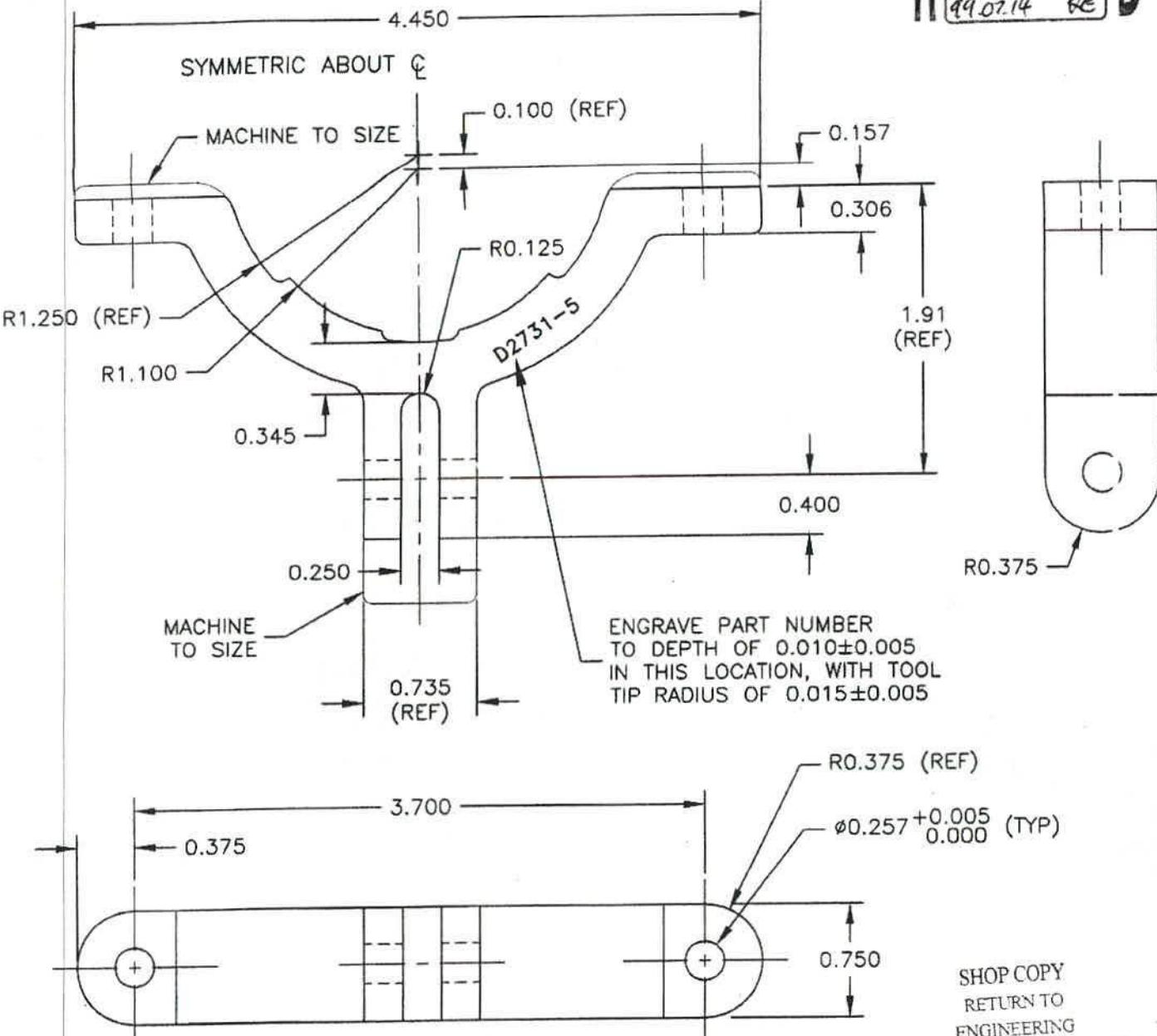
RELEASED
19.07.14 *KE*D2731-3

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. *33420*

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>CH</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 3 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 RE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 NO.

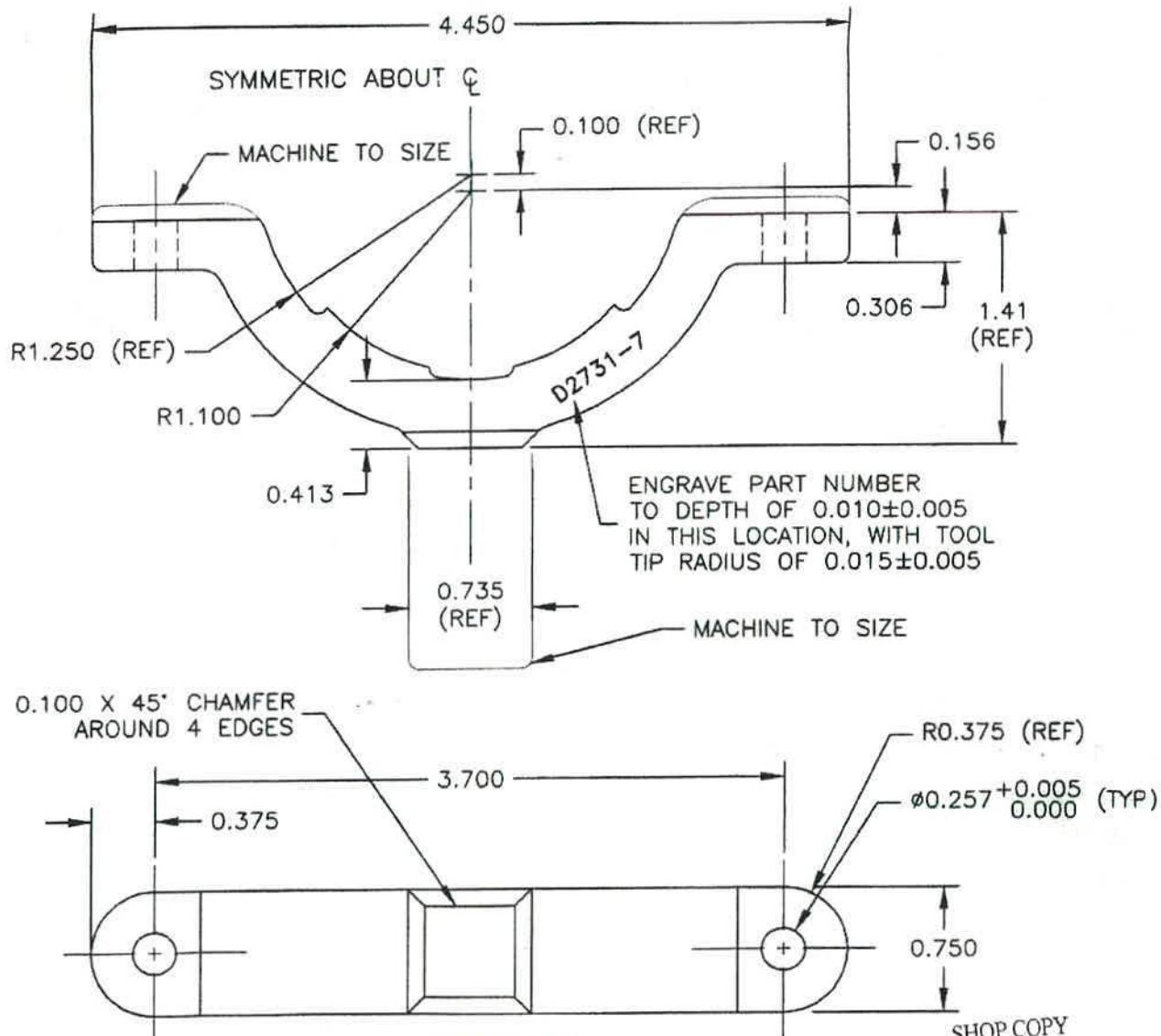
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
3342.0



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA		
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2731	REV. B	SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE	1:1

RELEASED
94.07.14 KJ



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33420



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
32	D2731-7	Lug B33420 MATERIAL: supplied by DART D2423 B23779	4191
18	D2731-7	Lug B33420 MATERIAL: supplied by DART D2423 B30062	4191

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz".

Shigi Walz

Vankleek Hill, August 23, 2007